

Work Order ID 150318

Wednesday, August 24, 2016 11:40:52 AM

150318

Page 1

Item ID: D350-749-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Low to High Gear Conversion

Start Date: 8/3/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **DAS 21** Date: **AUG 26 2016** Tooling: _____ Date: _____
QC: **9-89** Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-749	D		DAS 6 9-89					DAS 21 9-89	16-10-2
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP350-749-015 CHG 001 "NO DART ARC OR C OF C REQUIRED"								
								DAS 28 9-89	JAN 10 2017
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
								DAS 6 9-89	OCT 12 2016
								DAS 27 9-89	
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
								DAS 28 9-89	JAN 10 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 150318

Wednesday, August 24, 2016 11:40:52 AM

150318

Page 2

Item ID: D350-749-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Low to High Gear Conversion

Start Date: 8/3/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-749-015 Location : FG121 PPP Rev: _____ "NO DART ARC OR C OF C REQUIRED" **ATTN: ALL ORIGINAL EUROCOPTER ARC AND TAGS TO BE SHIPPED WITH KIT**								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89DAS
27
9-89

JAN 10 2017

DAS
21
9-89

JAN 10 2017

DAS
21
9-89

JAN 10 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : ☐			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Wednesday, August 24, 2016 11:40:51 AM

Page 1

Work Order ID: 150318

150318

Parent Item: D350-749-015

D350-749-015

Parent Item Name: Low to High Gear Conversion

Start Date: 8/3/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-02-14 DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
350A41-1088-20		Purchased	No			110	Each	4.0000	4	4	OCT 12 2016		
350A41-1088-20									**				
Strip, Chafing, Upper													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST594				4					DAS 27 9-89
				m134538				4					6 9-8
350A41-1090-20		Purchased	No			110	Each	2.0000	2	2	OCT 12 2016		
350A41-1090-20									**				
Strip, Chafing, Lower Front													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST595				2					DAS 27 9-89
				m134538				2					6 9-89
350A41-1089-20		Purchased	No			110	Each	2.0000	2	2			
350A41-1089-20									**				
Strip, Chafing, Lower Rear													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST594				2					DAS 27 9-89
				m134538				2					6 9-89
350A41-1092-22		Purchased	No			110	Each	4.0000	4	4			
350A41-1092-22									**				
Half Clamp													
	DAS 28 9-89			<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST595				4					DAS 27 9-89
				149895				4					6 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Wednesday, August 24, 2016 11:40:51 AM

Page 2

Work Order ID: 150318

Parent Item: D350-749-015

Parent Item Name: Low to High Gear Conversion

150318

D350-749-015

Start Date: 8/3/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

22201TK080018X

Purchased

No

110

Each

2.0000

2 2

22201TK080018X

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST567

2

m132111

2

23112TK080X

Purchased

No

110

Each

2.0000

2 2

23112TK080X

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

ST578

2

m134494

2

ASN52320BH120N

Purchased

No

110

Each

4.0000

2 2

ASN52320BH120N

NUT

DAS
28
9-89

Location

Loc Qty

Loc Code

ST556

4

121159

4

22201TK060070X

Purchased

No

110

Each

2.0000

2 2

22201TK060070X

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST567

2

m132111

2

**

OCT 12 2016

DAS
6
9-89
27
9-89

**

OCT 12 2016

DAS
6
9-89
27
9-89

**

OCT 12 2016

DAS
6
9-89
27
9-89

**

OCT 12 2016

DAS
6
9-89
27
9-89

Wednesday, August 24, 2016 11:40:51 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 150318

Wednesday, October 12, 2016 11:54:58 AM

150318

Page 1

Item ID: D350-749-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Low to High Gear Conversion

Start Date: 8/3/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-749	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP350-749-015 CHG 001 "NO DART ARC OR C OF C REQUIRED"								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

OCT 12 2016

REFERENCE ONLY

Qty -011	Qty -013	Qty -016	Qty -021	Qty -023	Qty -031	Qty -033	Part Number	Description
X							D350-748-011	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE
	X						D350-748-013	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE
		X					D350-748-016	STANDARD TO HIGH GEAR CONVERSION KIT
			X				D350-748-021	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
				X			D350-748-023	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE W/ RUN-ON LANDING WEARPLATE
					X		D350-748-031	LANDING GEAR KIT HIGH, AERAZUR / DART CYLINDRICAL FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
						X	D350-748-033	LANDING GEAR KIT HIGH, AIRCRUISER / DART TRI-BAG FLOAT COMPATIBLE W/ DELUXE SKIDTUBES
1	1		1	1	1	1	D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
1	1		1	1	1	1	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1							D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
1							D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
	1						D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE
	1						D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE
		1					D350-636-015	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
		1					D350-636-016	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
			1				D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
			1				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE WITH RUN-ON LANDING WEARPLATE
				1			D350-636-215	SKIDTUBE INSTALLATION, LH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
				1			D350-636-216	SKIDTUBE INSTALLATION, RH, STD AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE DELUXE
					1		D350-636-217	SKIDTUBE INSTALLATION, LH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE DELUXE
					1		D350-636-218	SKIDTUBE INSTALLATION, RH AIRCRUISER/DART TRI-BAG FLOAT COMPATIBLE DELUXE
		4					350A41-1088-20	STRIP, CHAFING, UPPER
		2					350A41-1090-20	STRIP, CHAFING, LOWER, FRONT
		2					350A41-1098-20	STRIP, CHAFING, LOWER, REAR
		4					350A41-1092-22	HALF, CLAMP
		2					22201TK060016X	SCREW
		2					23112TK080X	WASHER
		2					ASIN52320SH120N	NUT
		2					22201TK060070X	SCREW

*ADDITIONAL PARTS ARE REQUIRED WHEN SWITCHING FROM STANDARD TO HIGH GEAR ON AS350/355 AIRCRAFT. CUSTOMERS WHO ARE SWITCHING FROM STANDARD TO HIGH GEAR CAN PROCURE THE D350-748-015 CONVERSION KIT.

D	ADD -111/-113/-121/-123/-131/-133	CP	15.05.28
C	ADD -021/-023/-031/-033 KITS	RF	11.09.26
B	ADD D350-748-015 KIT FOR STANDARD TO HIGH GEAR CONVERSION	PH	08.02.08
A	NEW ISSUE	CP	08.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. REV. D D350-749 SHEET 1 OF 2	
CHECKED	<i>A.P.</i>	TITLE SCALE LANDING GEAR KITS NTS	
MFG. APPR.	<i>N/A</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED	<i>CA</i>	DATE 15.05.28	
DE APPR.			